

5/13

DART AEROSPACE LTD	Work Order:	22603
Description: Doubler	Part Number:	D3283-1
04.10.18 <i>AB</i> 04.10.18 <i>CP</i>		
Dwg: D3283 Rev. <i>AB</i>	Qty:	20
		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler Note: To be made in multiples of 10	<i>AB</i>	05.03.02	20
2	MV	Cut blanks: 15.550" x 2.000" Material: 6061-T6 (QQ-A-250/11) 0.063" thick (M6061T6S.063) Identify for D3283-1 Batch: <i>M17400</i>	<i>EN</i>	05/04/30	20
3	MV	Machine as per Folio FA424 and Dwg D3283 Stack of 10 Identify as D3283-1	<i>EN</i> <i>AB</i>	05/04/30	20
4	QC2	Inspect parts as they come off the CNC machine	<i>EN</i>	05/04/30	20
5	QC8	Second check	<i>ML</i>	05/04/30	20
6	MV	Deburr	<i>DB</i>	05/05/02	20
7	FP	Chemical Conversion Coat as per QSI 005 4.1	<i>FF</i>	05.06.07	20
8	QC5	Inspect work to Step 7	<i>2</i>	05.06.23	20
9	ST	Identify and Stock	<i>CL</i>	05/06/24	20
10	AC	Cost / part <i>8.56</i>	<i>AB</i>	05/06/27	20
11	DC	Close W/O <i>8.34</i> Inspect Level 21	<i>AB</i>	05.06.27	20

Rev	Date	Change	Revised By	Approved
A	04.09.28	New issue	KJ/JLM	<i>[Signature]</i>

RELEASED
[Signature] 05.09.29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

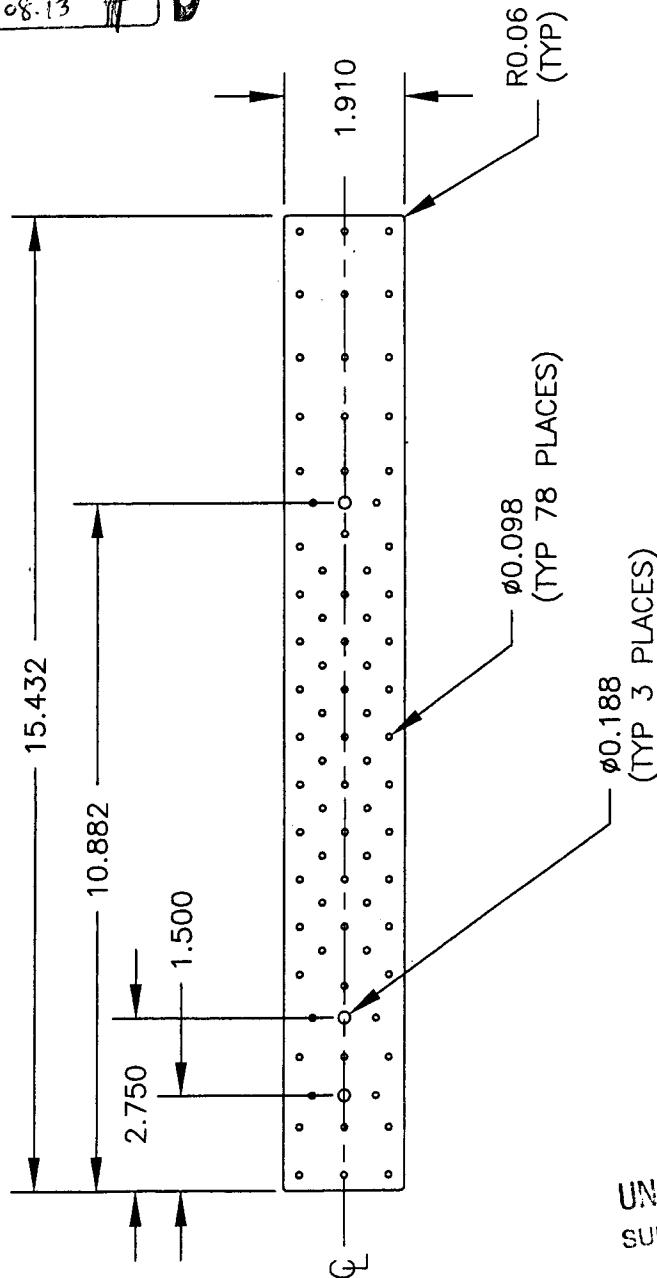
NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



DESIGN	UP	DRAWN BY	UP	DART AEROSPACE USA, INC.
				PORT HADLOCK, WA
CHECKED	TH	APPROVED	TH	DRAWING NO. D3283
				REV. B
				SHEET 1 OF 2
DATE	04.08.09	TITLE	DOUBLER	SCALE 1:3
A	04.05.06	NEW ISSUE		
B	04.08.09	10.882 WAS 11.502		

RELEASED
04.08.13



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SUBMIT TO THE
VENDOR
W/OUT ORDER
NO. 22603

D3283-1 DOUBLER

- 1) MACHINE PER DWG FILE "D3283-B1.DWG"
- 2) MATERIAL: 6061-T6, 0.063 THICK (QQ-A-250/11, REF DART SPEC. M6061T6S.063).
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

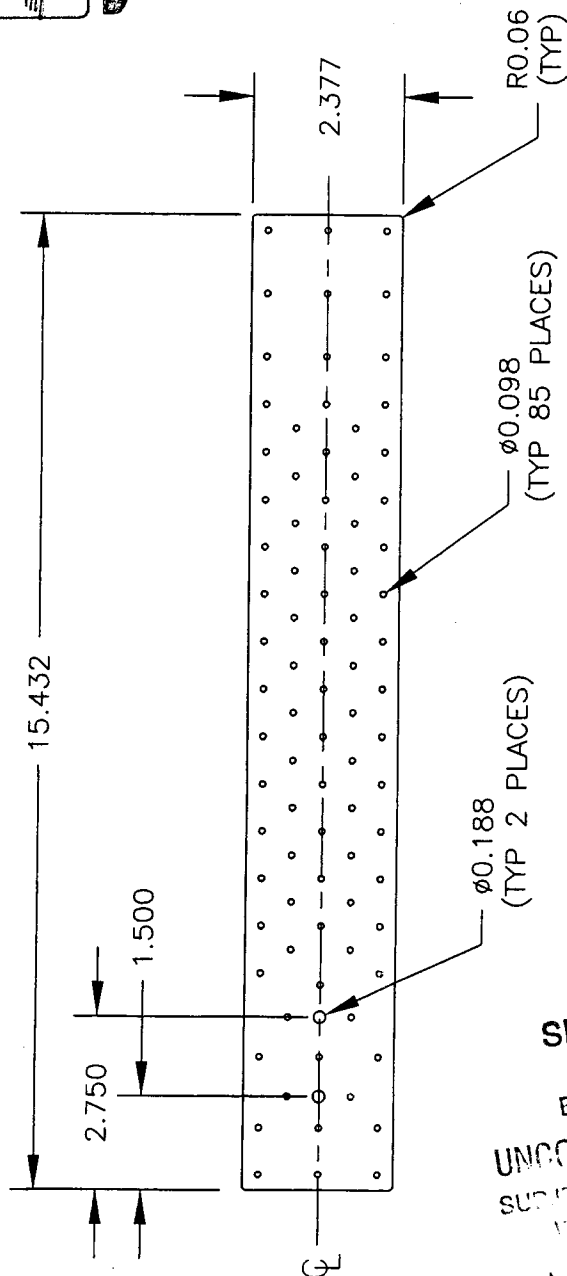
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DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3283	REV. B SHEET 2 OF 2
DATE 04.08.09		TITLE DOUBLER	SCALE 1:3

RELEASED
04.08.13 *[Signature]*



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10/1/09
NC. 22603

D3283-3 DOUBLER

- 1) MACHINE PER DWG FILE "D3283-B2.DWG"
- 2) MATERIAL: 6061-T6, 0.080 THICK (QQ-A-250/11, REF DART SPEC. M6061T6S.080)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Mar 01, 2005
11:19 am

Work Order No : 0022603
Project Name : D3283-1
Project For : WK513
Work Order Type : Main
Main WO Number :
House Part Number : D3283-1
Description : Doubler
Manufactured : Yes
Amount Req'd : 20
Amount Done : 0
Start Date : 03-01-05
Est Finish Date : 03-15-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Margin	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	0.00	0.00
Profits/(Loss)	0.00	0.00